

Work Order ID 58775

Tuesday, May 18, 2010 3:08:12 PM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mmf

Date:

10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4030

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Pick 5/18/20 (1)

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Assemble 5/18/20 (1)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

QC 5/18/20

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

Revision ID:

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Start Date: 5/18/2010 Start Qty: 1.00

Required Date: 5/28/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PMS 5/21

0.00

Packaging

PMS 5/21

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/2010

N 10-05-20

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Picklist Print

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Work Order ID: 58775

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC






IPP Rev:B as

Start Date: 5/18/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	6.0000	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST506		6						
					57736	1						
					57964	5						
D2535  Spring		Manufactured	No			100	Each	148.0000	2	57769		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		148						
					56355	48				56355		
					58331	100						
D2537  Bushing		Manufactured	No			100	Each	65.0000	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		65						
					53181	5				53181 30		
					57722	20				57722 30		
					58429	40						
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1			
						B 58239					SB 10/05/20	①
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1			
						B 58659					SB 10/05/20	①

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Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

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D3917-3  Washer		Manufactured	No			100	Each	24.0000	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST096				24				
				57144				1				
				58186				23				
D3953-3  Gas Spring Stud, Lid		Manufactured	No			100	Each	1.0000	2		<u>58186</u> <u>58858</u>	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				1				
				57978				1				
D3953-7  Spring Spacer		Manufactured	No			100	Each	9.0000	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				9				
				53970				9				
D3953-9  Gas Spring Washer		Manufactured	No			100	Each	26.0000	2		<u>53970</u>	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				26				
				53642				26				
										<u>53642</u>		

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3953-17 Gas Spring Spacer		Manufactured	No			100	Each	2.0000	2	 58807		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				2				
					57143			2				
D3953-19 Gas Spring Bracket		Manufactured	No			100	Each	11.0000	1	 52607		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				11				
					57607			11				
D3953-21 Gas Spring Bracket		Manufactured	No			100	Each	19.0000	1	 57146		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ENG				6				
					56407			6				
				ST102				13				
					57145			13				
D3969-3 Spring (Basket Lid)		Manufactured	No			100	Each	0.0000	1	 54111		

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Required Date: 5/28/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-14A 		Purchased	No			100	Each	86.0000	4	✓		
Bolt												

Location Loc Qty Loc Code

ST351 86

114330 86

AN3-16A Purchased No

100 Each 69.0000

2

114330



Bolt

Location Loc Qty Loc Code

ST352 69

113845 49

114523 20

AN5-17A Purchased No

100 Each 159.0000

4

113845



Bolt

Location Loc Qty Loc Code

ST323 54

114324 54

ST339 105

113538 5

114330 100

AN4-12 Purchased No

100 Each 44.0000

3

114324



Bolt

Location Loc Qty Loc Code

ST357 44

114292 44

114292

Per 5/23 ①

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Start Date: 5/18/2010

Required Date: 5/28/2010


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			100	Each	55.0000	3			


Location Loc Qty Loc Code

ST139 30
114341 30
ST314 5
113845 5
ST349 20
114341 20

AN310C4  Nut	Purchased	No				100	Each	76.0000	2			
---	-----------	----	--	--	--	-----	------	---------	---	--	--	--

Location Loc Qty Loc Code

ST349 76
114306 76

MS21042L3  Nut	Purchased	No				100	Each	1,426.000	6			
---	-----------	----	--	--	--	-----	------	-----------	---	--	--	--

Location Loc Qty Loc Code

ST300 1426
113537 20
113644 406
114523 1000

113845 20

114341 10

114306

1113644

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IPP Rev:B as

Start Date: 5/18/2010



Required Date: 5/28/2010

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			100	Each	565.0000	4	✓		
												
Nut												

Location	Loc Qty	Loc Code
ST300	565	
113523	26	
113537	3	
114108	36	114108
114437	100	
114449	400	

MS24665-151	Purchased	No			100	Each	686.0000	3				
												
Cotter Pin												

Location	Loc Qty	Loc Code
ST309	686	
17566	686	17566

MS24665-300	Purchased	No			100	Each	86.0000	2				
												
Cotter Pin												

Location	Loc Qty	Loc Code
ST309	86	
105279	2	
110123	84	110123

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Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
NAS1149F0432P		Purchased	No			100	Each	347.0000	6			
Washer												

Location	Loc Qty	Loc Code
ST275	347	
112940	92	
114405	1	
114576	254	

NAS1149F0563P Purchased

No

100

Each

260.0000

4



Washer

Location	Loc Qty	Loc Code
ST275	60	
108471	60	
ST298	200	
114576	200	

NAS1149F0332P Purchased

No

100

Each

887.0000

8



WASHER

Location	Loc Qty	Loc Code
ST275	887	
18057	887	

NAS1149C0432R Purchased

No

100

Each

182.0000

2



Washer

Location	Loc Qty	Loc Code
ST297	182	
114292	182	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

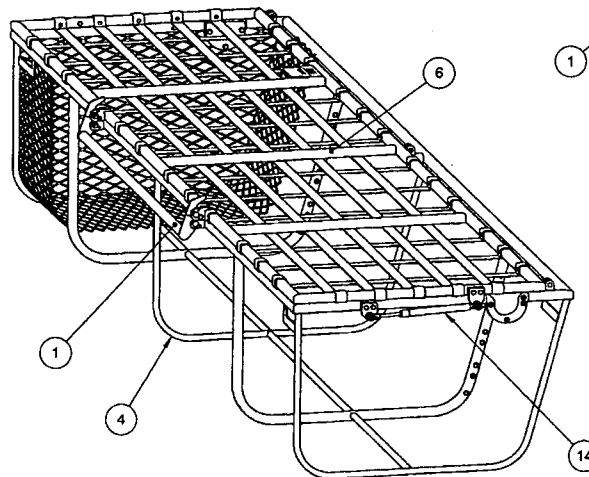
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

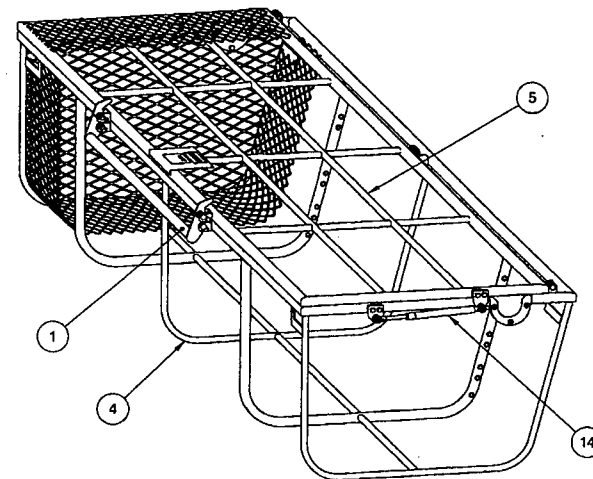
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
2010-04-14

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED	[Signature]	D4030	SHEET 1 OF 3
MFG. APPR.	[Signature]	TITLE	SCALE
APPROVED	[Signature]	LONG BASKET ASSY (350)	NTS
DE APPR.	[Signature]	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

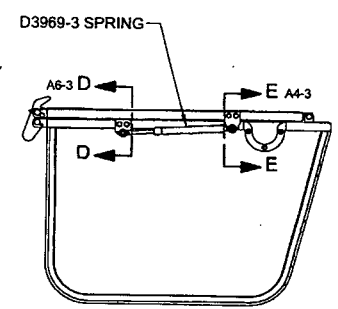
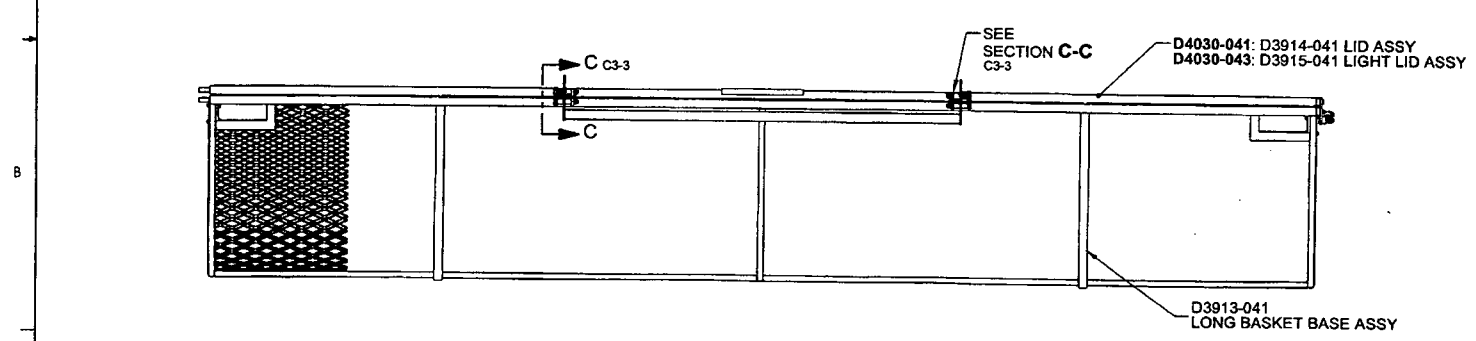
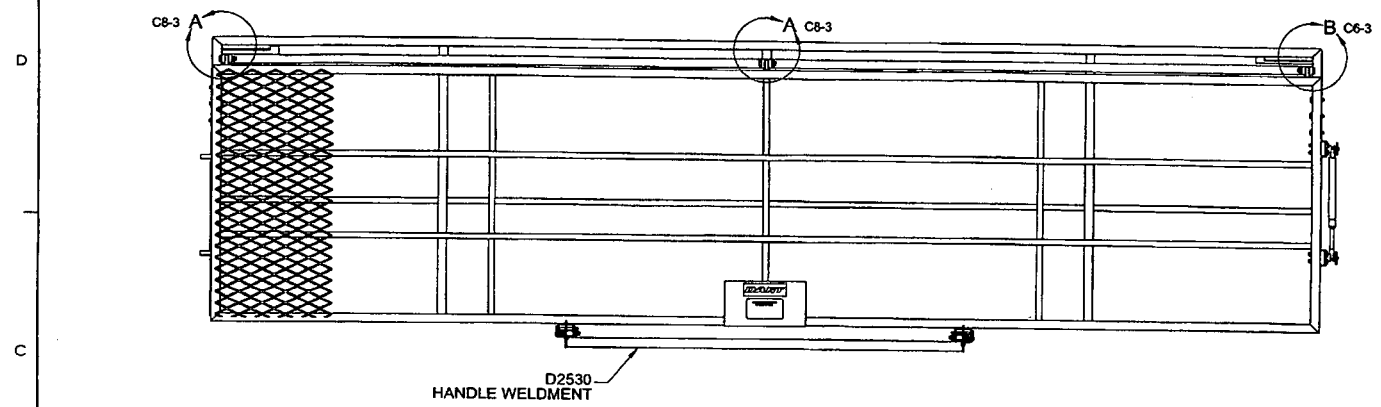
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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#58775





8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY. LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-04-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

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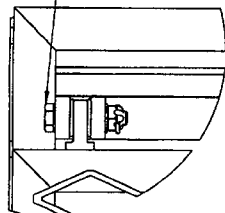
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

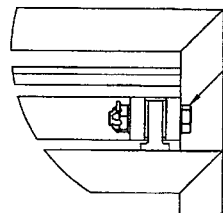
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

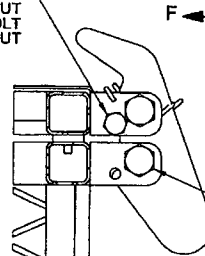


DETAIL A D8-2
D8-2



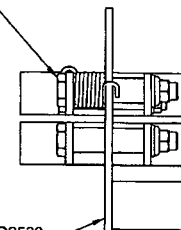
DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
2010-04-14
JMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4030	SHEET 3 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	LONG BASKET ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries